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(54) Self-hardening compound for  
making casting moulds and cores

(57) A self-hardening compound for  
making casting moulds and cores  
containing a refractory filler,  
orthophosphoric acid, a magnesia-  
spinellid-type compound roasted at a  
temperature of 1600 to 1900°C  
during 40 to 1600 hours, and water at

the following ratio of the said  
components in parts by weight:

orthophosphoric acid 2—10

the said magnesia-spinellid-  
type compound 2—20

water 0.5—6.0

refractory filler balance

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